

Date: Wednesday, 2/15/2006 3:44:12 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STRUT ASSEMBLY		
Job Number	: 25820					
Estimate Number	: 10732					
P.O. Number	: N/A			Part Number	: D23241	
This Issue	: 2/15/2006		S.O. No.	: N/A		
Prsht Rev.	: NC			Drawing Number	: D2324 REV. C	
First Issue	: N/A		Type	: SMALL /MED FAB		
Previous Run	: 25048			Project Number	: N/A	
Written By	: <u>Spec. comment Below</u>			Drawing Revision	: C	
Checked & Approved By	: <u>DK 06.02.16</u>			Material	: N/A	
Comment	: Est: E 03.02.28 Reformat; Incorporated D2324-3 & D2324-5 K J/RF			Due Date	: 2/28/2006	
				Qty:	20	Um: Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	25820A	STOP B = B25820 A(4) B = B20749(4)X B = B23494(4)(2)	
		Comment: Sub-Component STOP D2324-3	
2.0	25820B	STRAP	
		Comment: Sub-Component STRAP D2324-5 B B24528	
3.0	AN312A	Bolt	
		Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s) Bolt M18369	
4.0	AN960JD10	Washer	
		Comment: Qty.: 4.0000 Each(s)/Unit Total: 80.0000 Each(s) Washer M19413	
5.0	MS21042L3	Nut	
		Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s) Nut M18615	
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per Dwg D2324.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/03/15  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/15/2006 3:44:13 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT ASSEMBLY

Job Number: 25820

Part Number: D23241

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 QC5 INSPECT WORK TO CURRENT STEP



20603-01

Comment: INSPECT WORK TO CURRENT STEP

8.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

W 06/03/14 (20)

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

DC 06/03/14 (20)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST169

C Loc 03/15 (20)

11.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DC 06/03/15 (20)

Job Completion:



DC 06/03/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

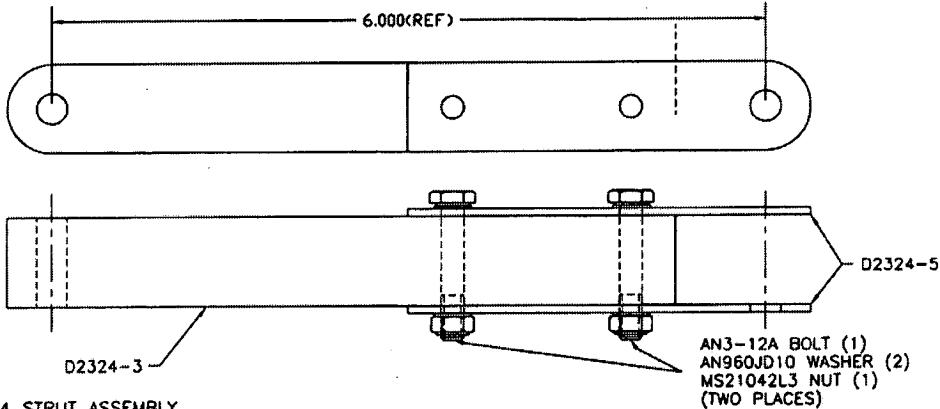
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

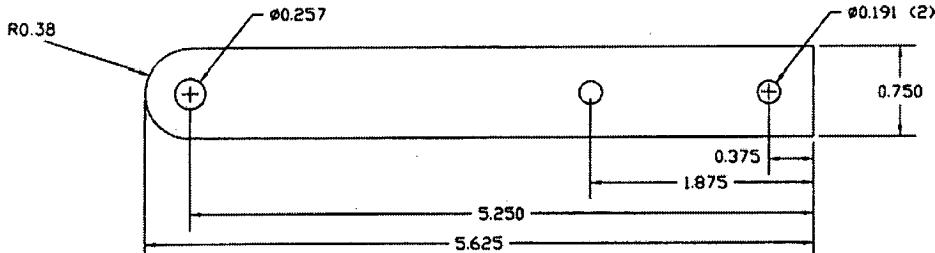
NOTE: Date & initial all entries

**DART**

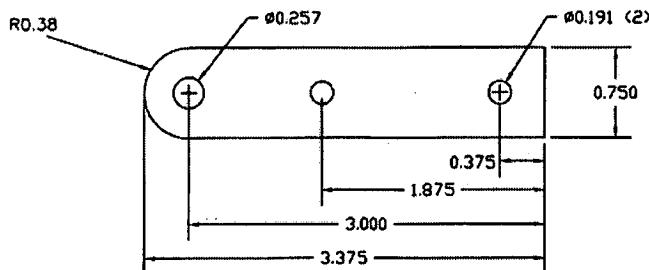
DESIGN B. WILLIAMS	DRAWN BY PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2324 REV. C SHEET 1 OF 1
DATE 04.12.14		TITLE STRUT
A	94.11.08	NEW ISSUE
B	96.05.07	UPDATE MATERIALS
C	04.12.14	UPDATE NOTES

**RELEASED**04.12.16 *[initials]***D2324 STRUT ASSEMBLY**

1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER

**D2324-3**

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75  
(REF DART SPEC. M6061T6B0.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2324-5**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 25830